

Work Order ID 62489

Thursday, September 30, 2010 2:23:37 PM



Page 1

Item ID:	D3774-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Seat Bottom, LH/RH					
Start Date:	9/30/2010	Start Qty:	2.00			
Required Date:	10/8/2010	Req'd Qty:	2.00			
Reference:						

Approvals:	Process Plan:		Date:	10/9/10	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3774	Rev B								

100		0.00							
	HAND FINISHING THERMOFORMING								
Thermoform	Memo	0.00							
Thermoforming Machine	Set up machine program D3774-1 <input type="checkbox"/> Set up clamping frame as per folio								

10/10/05

110		0.00							
	HAND FINISHING THERMOFORMING								
Thermoform	Memo	0.00							
Thermoforming Machine	Cut Blanks								

(X2) 10/10/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Revision ID:

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Start Date: 9/30/2010 Start Qty: 2.00

Required Date: 10/8/2010 Req'd Qty: 2.00

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

115



HandThermo

Hand Finishing Thermoforming

Dry Material

Memo

Dry Sheet as per QSI022 POLYCARBONATE

Temp: 240°F

Time IN: 4:30 10/10/04

Time OUT: 7:00 10/10/05

120



Thermoform

Thermoforming Machine

THERMOFORMING MACHINE

Memo

Thermoform as per Dwg. D3774-1 and Folio 1 Dwg. Rev.

3 □ Folio Rev. 2

130



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

BB 10/10/05

X2 BB 10/10/05

X2 BB 10/10/05

Dart Aerospace Ltd

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Page 3

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Setup Start

Revision ID:

Stop

Item Name: Seat Bottom, LH/RH

Start Date: 9/30/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 10/8/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140



Thermoform

Thermoforming Machine

HAND FINISHING THERMOFORMING

Memo

Trim to Finished Dimensions

0.00

0.00

X2

BB 10/10/05

150



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

1) Check dimensions to ensure conformity to drawing tolerances.

0.00

0.00

X2

BB 10/10/05

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Solidox

X2

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Page 4

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 Packaging Packaging	Identify as per dwg & Stock Location <u>257</u> Memo	0.00 0.00							
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

10/10/08
MF 10-10-07

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Picklist Print

Thursday, September 30, 2010 2:23:40 PM

Page 1

Work Order ID: 62489



Parent Item: D3774-1



Parent Item Name: Seat Bottom, LH/RH

Start Date: 9/30/2010

Required Date: 10/8/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A New Issue 08.06.04 DL verified by:DD
IPP REV. B Dwg. Update 08.08.19 DL IPP Rev. C
Add Step 105 Dry Material 10/04/21 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			110	sf	2,185.803	10.667	21.334			

GE PLASTICS LEXAN SHEET

Location

Loc Qty

Loc Code

MAT

2185.8038

114032

184.9238

115261

2000.88

X2

BB 10/10/09

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DART AEROSPACE LTD		Work Order: 62489
Description: Seat Bottom		Part Number: D3774-1
Inspection Dwg: D3774	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: <u>BB</u>	Date: 10/10/05
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3	+/-0.100	1.36	✓			
33.9	+/-0.100	33.8	✓			
17.4	+/-0.100 Min	17.6	✓			
0.085	Min	1.01	✓			
0.100	Min	.100	✓			
0.100	Min	.115	✓			
0.100	Min	.118	✓			
0.100	Min	.110	✓			

Measured by: <u>BB</u>	Date: 10/10/05
Audited by: <u>Ph</u>	Date: 10/10/05
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DL	<u>BB</u>

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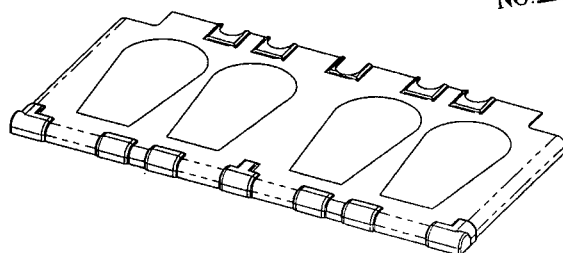
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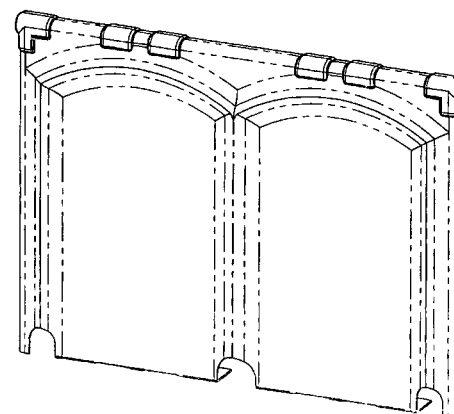
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SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 62489
BS10930



D3774-1 SEAT BOTTOM



D3774-3 SEAT BACK

RELEASED
 08-08-11/11

B	UPDATE CUTOUT DIMENSIONS (ZN D4-2, D6-2, C4-3, C7-3); UPDATE MINIMUM THICKNESS (ZN A5-2, A5-3); ADD HOLES ON D3774-3 (ZN B6-3) REASON: MANUFACTURING CAPABILITIES	PH	08.07.25
A	NEW ISSUE	HS	08.06.23
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3774 TITLE SEAT SCALE NTS	
DRAWN	PH		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH	REV. B SHEET 1 OF 3	
DATE	08.07.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

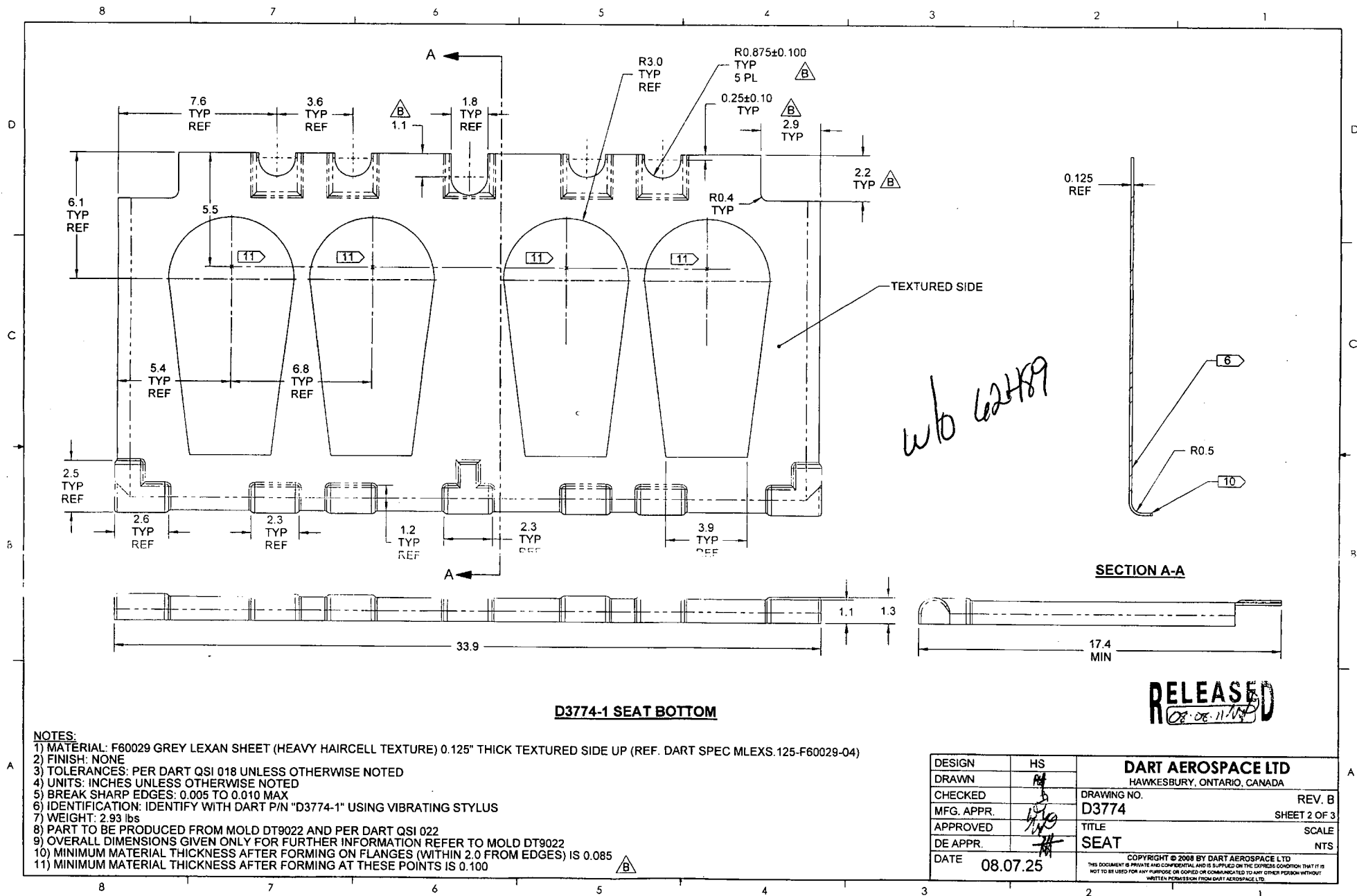
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8

7

6

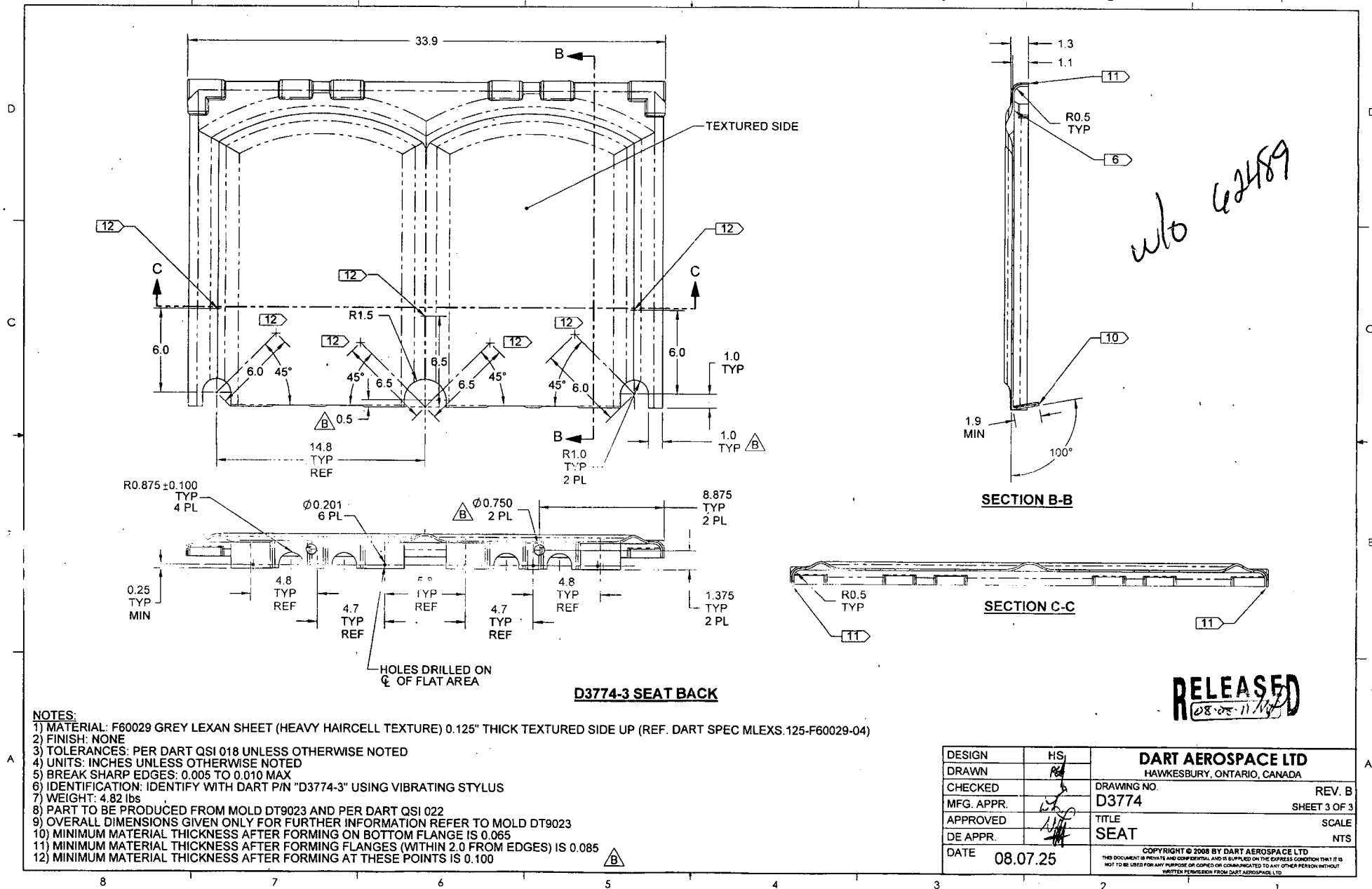
5

4

3

2

1



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